

Date: Thursday, 4/12/2007 8:45:07 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 31720	
Estimate Number : 10531	
P.O. Number : <u>NIA</u>	Part Number : D2572
This Issue : 4/12/2007 S.O. No. : <u>NIA</u>	Drawing Number : D2572 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NIA</u> Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 31714	Material : <u>NIA</u>
Written By : <u>[Signature]</u>	Due Date : 4/30/2007 Qty: 16 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6101005	7075-T7351 8.25X5.0X2.5
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  
 7075-T7351 8.25X5.0X2.5  
 Make from D6101-005 billet for D2572  
 Ensure that grain is along 5.00" length  
 Batch No: \_\_\_\_\_

B25352 (X9) En 07/5/15  
B25350 (X7)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. B31720 Double check by: JL

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
 4-Deburr and remove all machining marks  
 5-Tumble to remove shap edges.

En/M8 07/05/23 16

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2571 & D2572

En 07/05/23 16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 07/05/23 16

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RL Date: 07/05/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 4/12/2007 8:45:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 31720

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

3.2 07/05/23

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-H

07/05/24

(16X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103141

M

07-05-25 (16)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7/5/28 SA

10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51432

PU

7/5/28

SA

16

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/29 (16)

Job Completion



07-05-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	31720
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	D2572
<b>Inspection Dwg:</b> D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.947	1.150	1.750	1.750		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.747	1.750	1.750	1.749		
E	7.990	8.010		7.994	7.997	7.998	8.000		
F	0.490	0.510		0.494	.497	.495	.496		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.493	.498	.499	.500		
J	1.174	1.184		1.175	1.178	1.179	1.179		
K	0.558	0.578		0.564	.565	.565	.564		
L	1.174	1.184		1.175	1.178	1.179	1.179		
M	1.490	1.500		1.492	1.498	1.499	1.499		
N	2.495	2.505		2.498	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.874	3.874	3.874		
P	0.115	0.135		0.126	.128	.128	.128		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	.253	.252	.251		
S	0.115	0.135		0.121	.125	.125	.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.966	2.960	2.960	2.960		
V	0.230	0.250		0.240	.240	.240	.240		
W	0.115	0.135		0.126	.128	.128	.128		
X	0.307	0.312		0.311	.312	.312	.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	.362	.362	.362		
AA	0.470	0.530		0.520	0.520	0.520	0.520		
AB	0.615	0.635		0.626	.628	.629	.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	.250	.247	.249		
AE	1.375	1.395		1.385	1.387	1.387	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	En / MB
Date:	07/05/17

Audited by:	J.L
Date:	07/05/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>31720</b>
<b>Description: Saddle, Fwd Inboard</b>	<b>Part Number:</b>	<b>D2572</b>
<b>Inspection Dwg: D2572 Rev. E</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440	0.440	0.440		
B	1.745	1.755		1.747	1.750	1.745	1.756		
C	3.495	3.505		3.500	3.500	3.499	3.499		
D	1.745	1.755		1.751	1.750	1.745	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.500	.500	0.496	0.496		
G	0.257	0.262	DT8683	.258	.258	0.260	0.260		
H	0.375	0.380	DT8684	.376	.376	0.377	0.377		
I	0.490	0.510		.500	.500	0.495	0.494		
J	1.174	1.184		1.179	1.178	1.174	1.176		
K	0.558	0.578		.567	.568	0.563	0.567		
L	1.174	1.184		1.178	1.179	1.174	1.176		
M	1.490	1.500		1.496	1.496	1.494	1.492		
N	2.495	2.505		2.500	2.500	2.498	2.499		
O	3.869	3.879		3.873	3.874	3.874	3.876		
P	0.115	0.135		.128	.128	0.127	0.127		
Q	0.115	0.135		.125	.125	0.135	0.135		
R	0.240	0.260		.250	.250	0.253	0.252		
S	0.115	0.135		.128	.127	0.122	0.120		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.960	2.960	2.960		
V	0.230	0.250		.242	.240	0.240	0.235		
W	0.115	0.135		.125	.125	0.127	0.122		
X	0.307	0.312		.310	.310	0.311	0.311		
Y	0.760	0.765		.762	.762	0.765	0.765		
Z	0.352	0.372		.365	.365	0.365	0.365		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		.622	.625	0.625	0.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.252	.252	0.244	0.245		
AE	1.375	1.395		1.385	1.384	1.384	1.382		
AF	0.115	0.135		.125	.125	0.135	0.135		
AG	0.240	0.280		.262	.260	0.260	0.260		
AH	0.240	0.260		.250	.250	0.250	0.245		
AI	2.000	2.020		2.001	2.000	2.000	2.000		
AJ	0.023	0.043		.032	.032	.032	.032		
Accept/Reject									

Measured by: <b>MS</b>	Audited by: <b>SA</b>
Date: <b>01/03/18 07/05/19</b>	Date: <b>07.05.21</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	31720
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	D2572
<b>Inspection Dwg:</b> D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.747	1.748	1.748		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.747	1.748	1.748		
E	7.990	8.010		8.001	8.001	8.002	8.002		
F	0.490	0.510		0.501	0.498	0.497	0.496		
G	0.257	0.262	DT8683	0.266	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.498	0.496	0.495	0.495	
J	1.174	1.184		1.174	1.175	1.174	1.178		
K	0.558	0.578		0.567	0.565	0.567	0.564		
L	1.174	1.184		1.174	1.175	1.174	1.178		
M	1.490	1.500		1.494	1.496	1.494	1.492		
N	2.495	2.505		2.498	2.497	2.496	2.497		
O	3.869	3.879		3.873	3.872	3.870	3.874		
P	0.115	0.135		0.127	0.127	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.252	0.251	0.251		
S	0.115	0.135		0.124	0.124	0.124	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.238	0.239	0.240	0.241		
W	0.115	0.135		0.121	0.121	0.125	0.124		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.365	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.630	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.247	0.246	0.249		
AE	1.375	1.395		1.387	1.387	1.386	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.248	0.248	0.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	En
Date:	07/05/20

Audited by:	SA
Date:	07.05.21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	31720
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	D2572
<b>Inspection Dwg:</b> D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.746	1.748	1.748	1.750		
C	3.495	3.505		3.498	3.500	3.500	3.500		
D	1.745	1.755		1.746	1.749	1.750	1.750		
E	7.990	8.010		8.002	8.000	8.002	8.001		
F	0.490	0.510		0.500	.501	.501	.500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.496	.496	.497	.497		
J	1.174	1.184		1.175	1.179	1.179	1.179		
K	0.558	0.578		0.565	.565	.565	.565		
L	1.174	1.184		1.175	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.496	2.499	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.125	.128	.128	.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	.250	.253	.250		
S	0.115	0.135		0.124	.125	.128	.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.236	.238	.240	.240		
W	0.115	0.135		0.128	.127	.128	.129		
X	0.307	0.312		0.312	.312	.312	.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	.363	.362	.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	.625	.625	.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	.247	.245	.247		
AE	1.375	1.395		1.386	1.388	1.388	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	.248	.247	.247		
AI	2.000	2.020		2.006	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

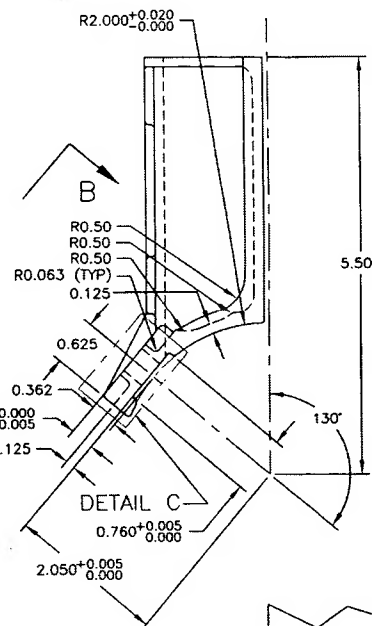
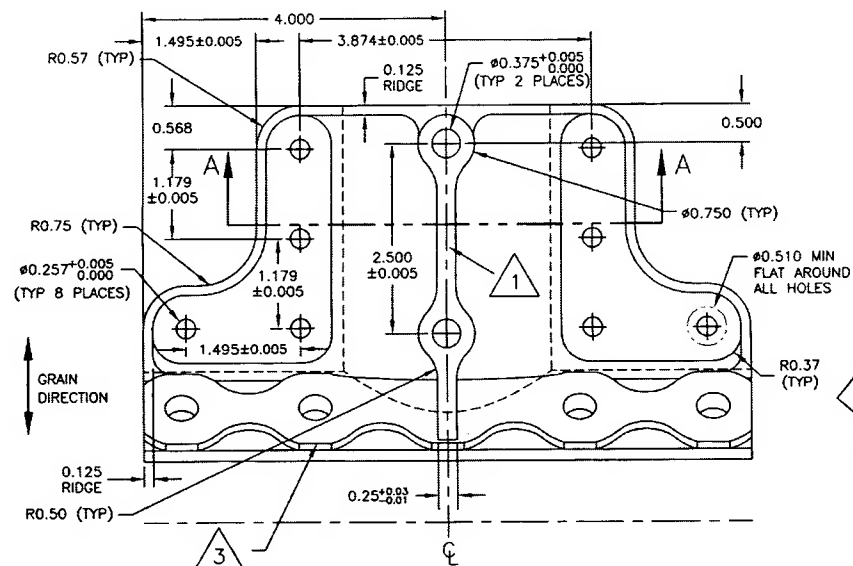
Measured by:	En/M8
Date:	07/05/23

Audited by:	JL
Date:	07/05/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



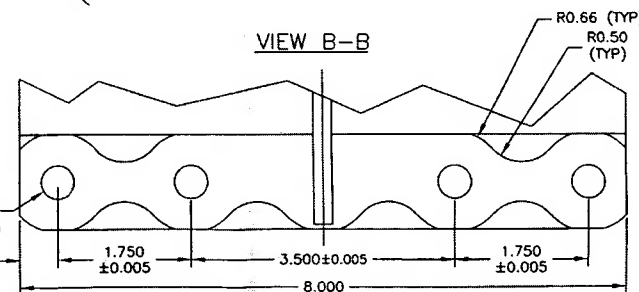
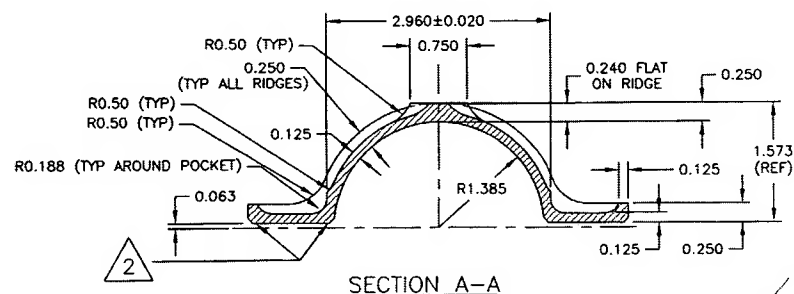
05.12.06



## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED


- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



DETAIL C  
SCALE 2:1

**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN	DRAWN BY	 <b>DART AEROSPACE LTD.</b> MARKHAM, ONTARIO, CANADA	
DS	PH		
CHECKED	APPROVED	DRAWING NO. D2572	REV. SHEET 1 OF 2
DATE		TITLE INNER FWD SADDLE	SCALE
05.07.13			2

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31720